5/26

DART AEROSPACE LTD.	Work Order:	23508
Description: Saddle Fitting, Fwd (Outboard/Inboard)	Part Number:	D2571/D2572
<b>Drawing:</b> D2571 Rev. D/D2572 Rev. D	Qty:	8
		Page 1 of 1

Step	Location	Procedure	Ву	Date	Qty
1	DC	Issue Traveller	100	65 01 01	8
		Dwg not required	170	05.06.06	
2	MV	Make from D6101-007 billet for D2571			
1		Ensure that grain is along 7.75" length	E	C '6	0
		Batch No: B23250	14	05.06.18	8
3	MV	Make from D6101-005 billet for D2572			
		Ensure that grain is along 5.00" length	14	~~ ~	8
		Batch No: B23249	0	05.06.18	8
4	MV	Fixturing W/O No	1//	$\Lambda_{-}$	8
		rixturing inspection last completed by	r v /	T	8
5	MV	Program Batch No. <u>3/.</u> Double check by: <u>M</u>	Ba	65.06.22	8
	h 4) (		00	C 3. CG . CC	8
6	MV	Machine Step No 1 per Folio FA051 and inspect per attached	136	65.06.27	8
,	A 4) /	Dimension Sheets  Machine Step No 2 per Folio FA051 and inspect per attached		-	
7	MV	Dimension Sheets	BC	es. 66.27	8
8	MV	Machine Step No 3 per Folio FA051 and inspect per attached			
°	IVIV	Dimension Sheets	TSC.	05.66.22	8
9	MV	Machine keyway as per dwg D2571 & D2572			
١	1010	Machine Reyway as per awg bzor i a bzorz	136	65.66.27	8
10	MV	Deburr and remove all machining marks			
			736	65.06.22	8
11	MV	Tumble for 20 minutes to remove shar edges of 04 a 21			C.
		中 机 04-00	136-	25.06.22	8
12	QC1	Inspect all dimensions to dimension sheets	21		e-
	,	'	BG	es.c6 22	8
13	QC7	Second inspection	7.1	1 ,	70
			The	05/06/22	8
14	FP	Acid etch and alodine as per QSI 005 4.1	ash	a to di	X
			117	050904	0
15	FP	Powder Coat High Gloss White (4.3.5.1) per QSI 005 4.3	61	CK Con CK	Q
		, in the second	10	OS 07 US	0
16	QC3	Inspect Powder Coat	Val	05 07 06	8
			1//	0)0/0	<i>V</i>
17	ST	Identify and Stock.	10 ×	05/07/06	8
			100	-3/0/10G	<u>8</u>
18	AC	2011 Part 18/11 196/18	5.0	0508-02	8
		Cost / Part / 8/.// / 194./8 Close W/O / 68.89 / 45./8	,	20.02	
19	DC	Ulose VV/O / 60 , 8  / Y S , / Z	1	achilar	8
		Inspection Level 21	1	101/01	L <del>-</del>

Rev	Date	Change	∨Revised By	Approved
G	01.04.27	Added D6101-007 & step 8	EC	1
Н	02.02.01	Added Inspection level 5 and Inspection Level 21	SM	
T	02.10.02	Re-format; Change to Dwg Rev. D & incorporated D2572	KJ RF	



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